

Date: Wednesday, 12/5/2007 10:36:39 AM  
 User: Kim Johnston

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT FRAME ASSEMBLY
Job Number :	36145		
Estimate Number :	11122		
P.O. Number :		Part Number :	D3016041
This Issue :	12/5/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3016 REV A
First Issue :	11	Project Number :	N/A
Previous Run :	34894	Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	<i>[Signature]</i>	Due Date :	1/10/2008
Comment :	Est. A 01.09.19 New issue EC	Qty:	2 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 6.8250 f(s)/Unit Total: 6.8250 f(s)

4130 Tube .750 OD x.049W

Cut- AISI 4130N tube, Ø3/4" x 0.049" wall

Batch: *M100843*

PD 08.01.21

2.0	M4130NT1000W049	4130 Tube 1.0"D X .049"W
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Comment: Qty.: 2.6250 f(s)/Unit Total: 2.6250 f(s)

4130 Tube 1.0"D X .049"W

*M103433 min 2008/2/08*

PD 08.01.21

3.0	M4130NT0500W049	4130 Tube .500 OD x.049W
-----	-----------------	--------------------------



Comment: Qty.: 4.2000 f(s)/Unit Total: 4.2000 f(s)

4130 Tube .500 OD x.049W

Cut- AISI 4130N tube, Ø1/2" x 0.049" wall

Batch: *M103289**M103788 min 2008/2/08*

PD 08.01.21

4.0	D301617	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
1	D3016-17	Gusset	<i>B22066</i>

PD 08.01.21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/5/2007 10:36:39 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 36145

Part Number: D3016041

Job Number:



Seq. #	Machine Or Operation:	Description :
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5.0	D301613	Bracket
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
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1	D3016-13	Bracket	
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B216404 → 1

B34208 → 1

PD 08.01.21

6.0	D301615	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
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1	D3016-15	Gusset	
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B25762

PD 08.01.21

7.0	D30201	Fitting
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
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2	D3020-1	Fitting	
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B36713

PD 08.01.21

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11/08/01/21

9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Weld as per Dwg D3016

A/R Steel Rod Batch: M100075

4-Transfer Drill Holes to D3016-041 From D3021-041

PD 08.01.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: JD Date: 08/02/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 10:36:39 AM  
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Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 36145

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/01/29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/29

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

m-k 08/02/05

(2X)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-05

(2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

WF 08-02-07

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



2008/2/08

(2)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

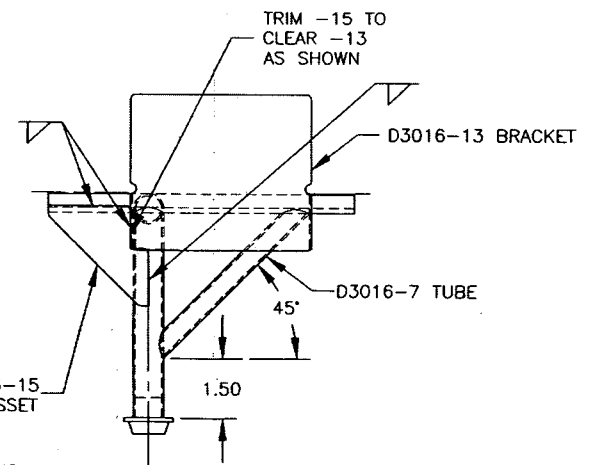
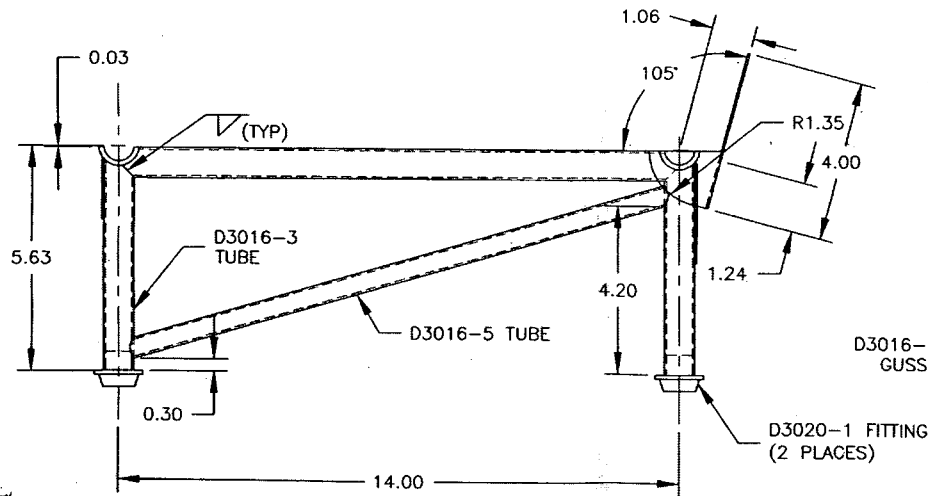
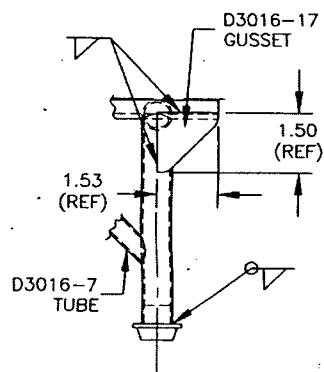
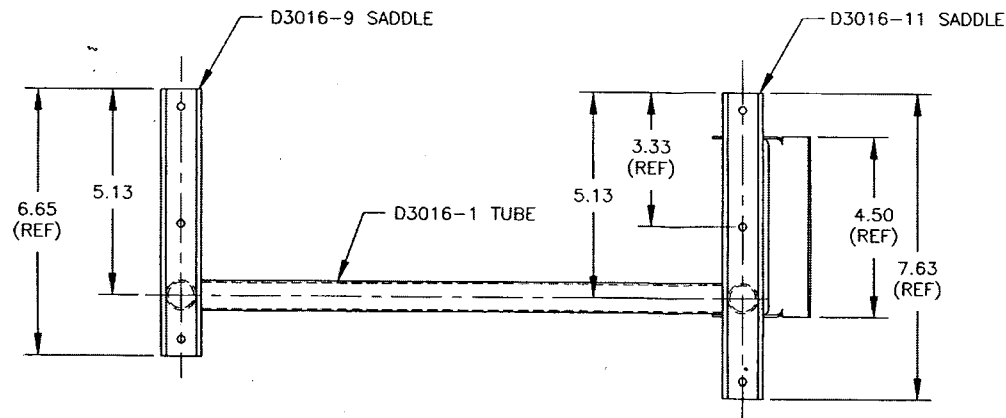
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# D3016-041 SEAT FRAME ASSEMBLY



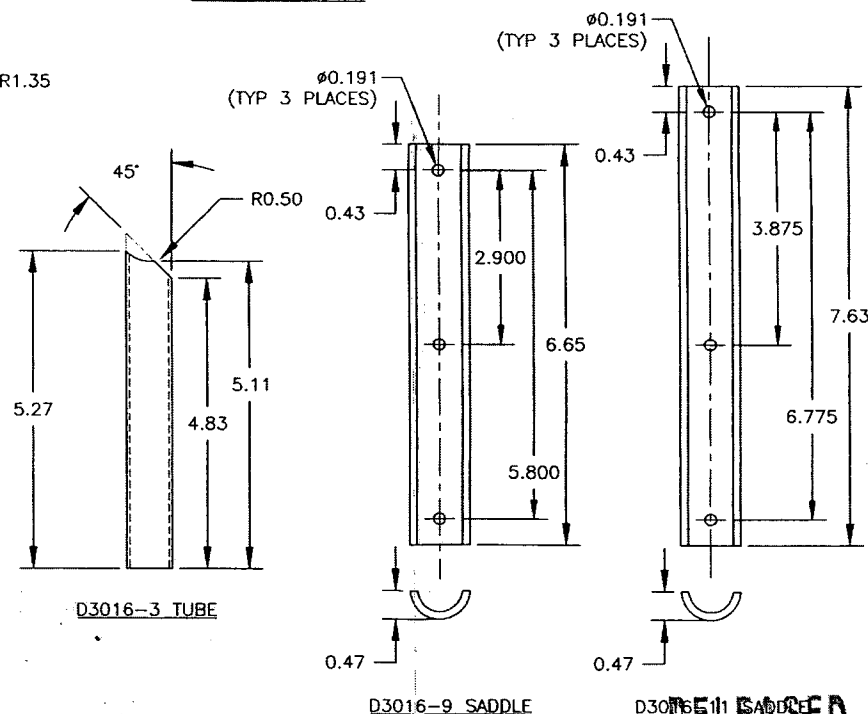
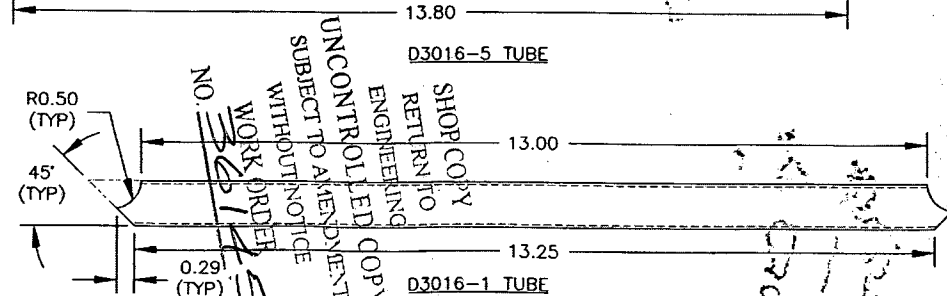
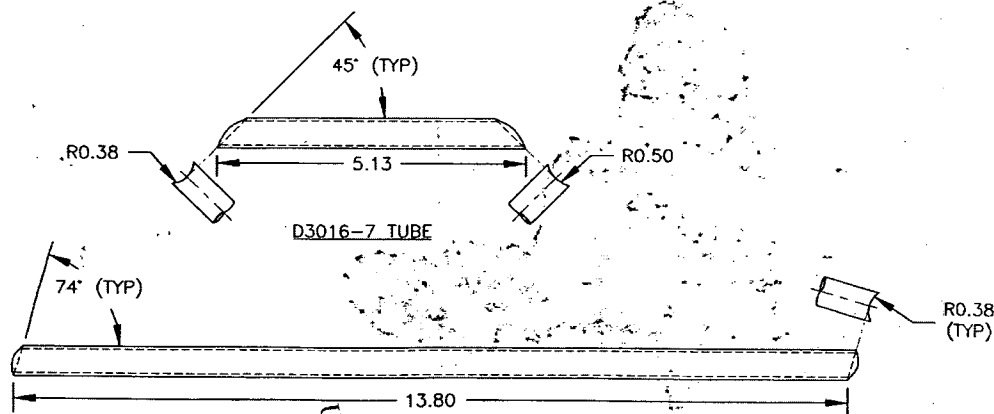
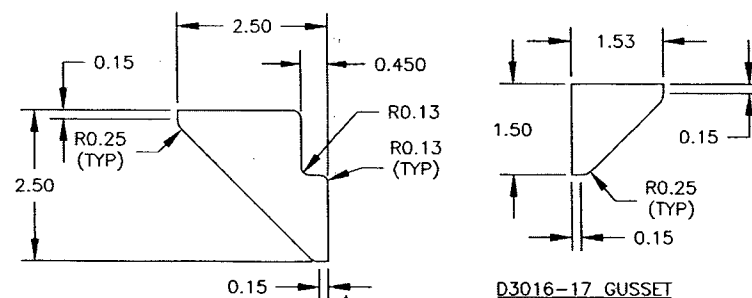
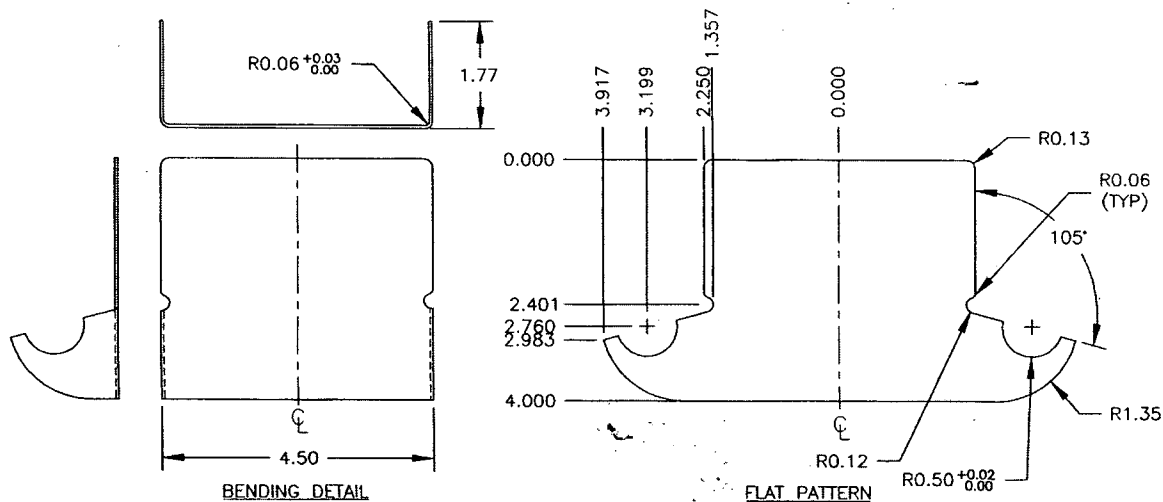
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CHECKED	#	APPROVED	#	DRAWING NO. D3016	REV. A SHEET 2 OF 3
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	SCALE	1:3



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CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A SHEET 3 OF 3
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE 1:2	

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9.05.30

